

# SETUP & OPERATION MANUAL

## FEATURES

Router lift for Excalibur cast-iron tables #40-070 and #40-075, MDF tables #40-047 and #40-049 & phenolic tables #40-043 and #40-045.

- Heavy-duty massive router lift with 9 1/4" x 11 3/4" aluminum top plate.
- Stable 4 post/lift screw design & chain drive lifting system controlling all 4 corners simultaneously.

## ***ROUTER LIFT*** ***for Excalibur router tables***



# MODEL

## #40-125



JANUARY 03/13  
© Copyright General® International 01/2013





## **GENERAL® INTERNATIONAL**

8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3  
Telephone (514) 326-1161 • Fax (514) 326-5555 • [www.general.ca](http://www.general.ca)

## **THANK YOU**

for choosing this Excalibur by General® International model #40-125 Router Lift. This router lift has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. For your safety, as well as to ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this router lift as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

---

**Disclaimer:** The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corres-

ponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of router lift and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

# GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

## **Limited Lifetime Warranty**

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

## **Standard 2-Year Limited Warranty**

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

## **To file a Claim**

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

## **CONDITIONS AND EXCEPTIONS:**

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

***Repairs made without the written consent of General® International will void all warranty.***

# Rules for Safe Operation

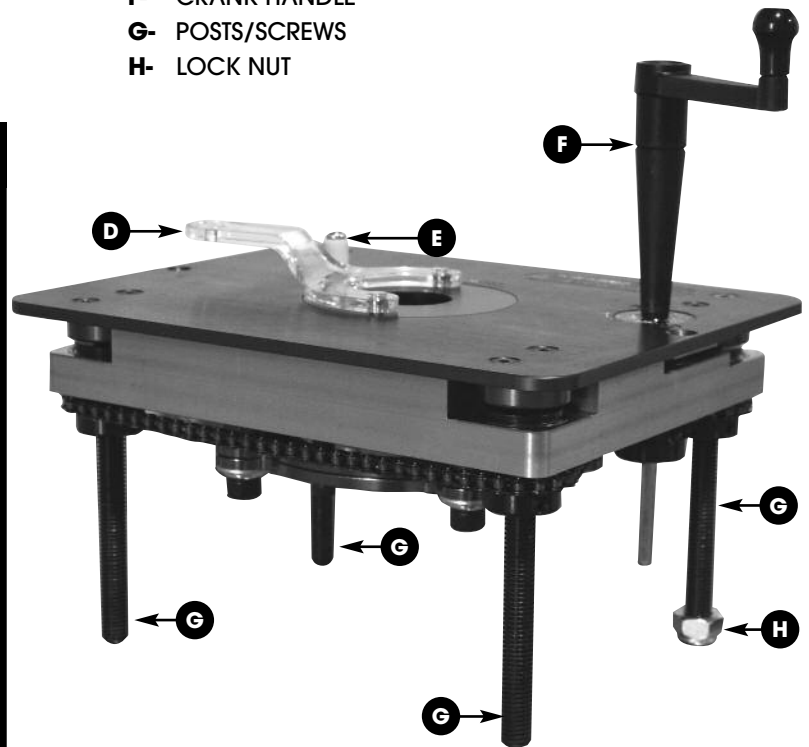
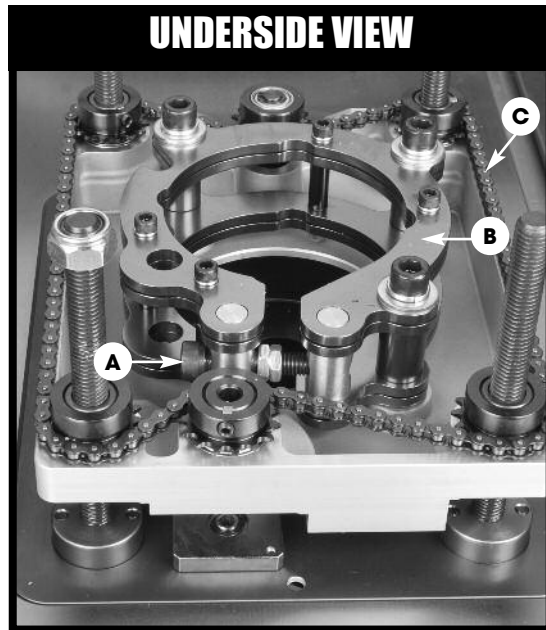
To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. **GENERAL® INTERNATIONAL** disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Make sure that the operator has been properly trained and has read and understands the Owner's Manual before operating any machinery.
2. Be sure to read, understand and follow all instructions, warnings and safety guidelines supplied with your router.
3. Do not operate this router table when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
4. Keep the work area well lit, clean and free of debris.
5. Stay Alert! Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Do not wear loose clothing, gloves, bracelets, necklaces, or other jewelry. Wear face, eye, ear, respiratory and body protection devices. Wear protective hair covering to contain long hair and wear non-slip footwear.
7. Keep hands and other body parts well away from bits or cutting tools. When working close to the cutting tool, always use a feather board or push-stick to hold or guide the workpiece. Do not clear chips and sawdust away with hands. Use a brush.
8. Fine particulate dust is a carcinogen that can be hazardous to health. Always work in a well ventilated area and whenever possible use a dust collector to minimize health hazards.
9. Be sure the router is running up to speed before feeding the workpiece.
10. Use a suitable support if stock does not have a flat surface.
11. Keep children and visitors at a safe distance when the router is in operation – do not permit them to operate the router and table.
12. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
13. Secure the table to a work surface and never stand or lean on it. Serious injury could occur if the table is tipped or if unintentional contact is made with spinning router bit.
14. Keep all guards and safety devices in place and in good working order. If a guard must be removed for maintenance or cleaning make sure it is properly re-installed before using the machine again.
15. Hold the workpiece firmly against the table and use suitable support if the workpiece does not have a flat surface.
16. Feed the stock into the bit against the rotation direction of the bit. Never run the stock between the fence and the bit.
17. Do not operate with a damaged bit in the router.
18. Always disconnect the router from the power source before changing accessories or before performing any maintenance and adjustments or if the machine will be left unattended.
19. Be sure that all adjustment tools, wrenches or other clutter are removed from the table surface and safely stored before routing.
20. Make sure the routers switch is in the "OFF" position before plugging in to a power source.
21. Avoid working from awkward or off balance positions. Do not overreach and always keep both feet firmly on the floor.
22. Never leave the router unattended while running or with the power on.
23. Do not use this router table for any purpose other than its intended use. If used for other purposes, **GENERAL® INTERNATIONAL** disclaims any real or implied warranty and holds itself harmless for any injury which may result from such use.

# IDENTIFICATION OF MAIN PARTS AND COMPONENTS

- A- CLAMPING BOLT
- B- CLAMPING BRACKET
- C- CHAIN
- D- INSERT RING WRENCH

- E- STARTING PIN
- F- CRANK HANDLE
- G- POSTS/SCREWS
- H- LOCK NUT



## UNPACKING

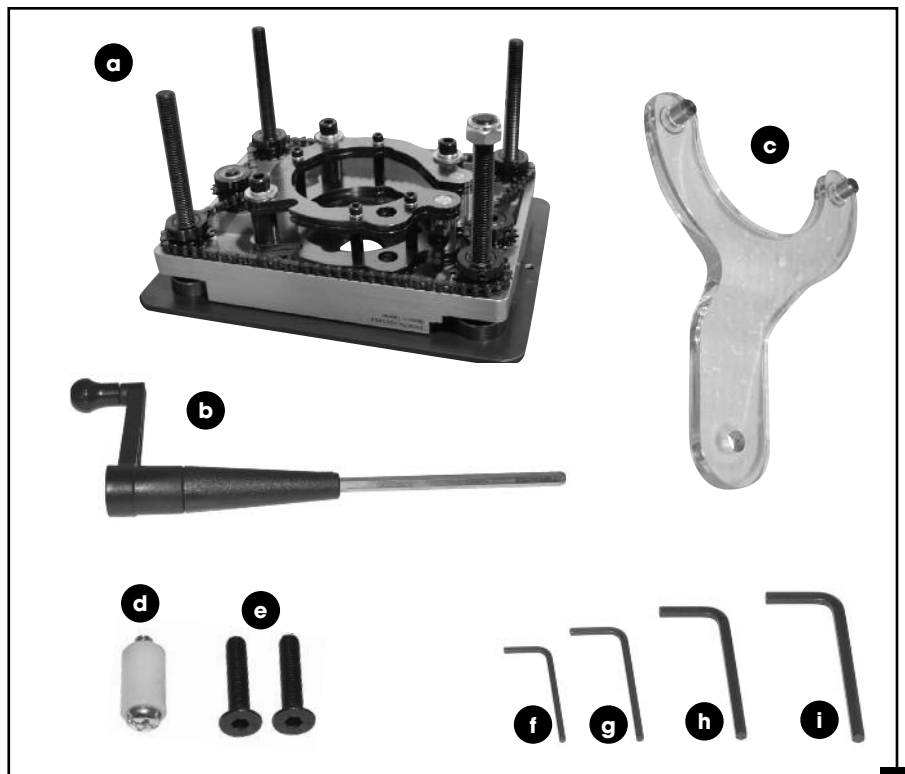
Carefully unpack and remove the router lift and its components from the box and check for damaged or missing items as per the list of contents below.

**NOTE:** Please report any damaged or missing items to your General International distributor immediately.

### LIST OF CONTENTS

### QTY

a- ROUTER LIFT	1
b- ROUTER LIFT CRANK HANDLE	1
c- INSERT RING WRENCH	1
d- STARTER PIN	1
e- HEX SOCKET HEAD BOLT	2
f- 2.5 MM ALLEN KEY	1
g- 3 MM ALLEN KEY	1
h- 4 MM ALLEN KEY	1
i- 6 MM ALLEN KEY	1



# ASSEMBLY INSTRUCTIONS - *PREPARE THE TABLE \* FOR ROUTER LIFT*

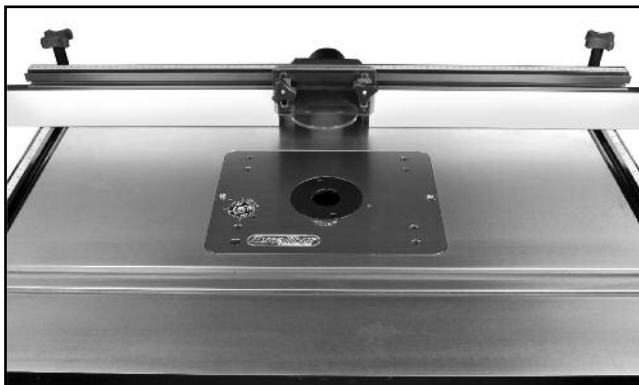


SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

## \* Excalibur Router Tables.

**Note regarding installation on shop-made or non-Excalibur router tables:** Before constructing your own table top, take note that Excalibur does not use leveler set screws in their router plates or lifts. Instead each Excalibur router table includes it's own built-in leveling system. The reason for this is that on shop-made table tops made of wood or MDF, metal set screw levelers in the router plate will eventually sink into the softer material of the table and become ineffective. If you are installing this router lift in a shop made router table or on another brand of router table that does not include a built-in levelling sytem **PLEASE SEE/USE THE EXCALIBUR #40-092 LEVELER BAR KIT DESIGNED SPECIFICALLY FOR USE WITH SHOP-MADE TABLE TOPS.**

**Note:** Model #40-075 for 40-200C Cast-iron table shown. The following steps apply to all Excalibur router table options.



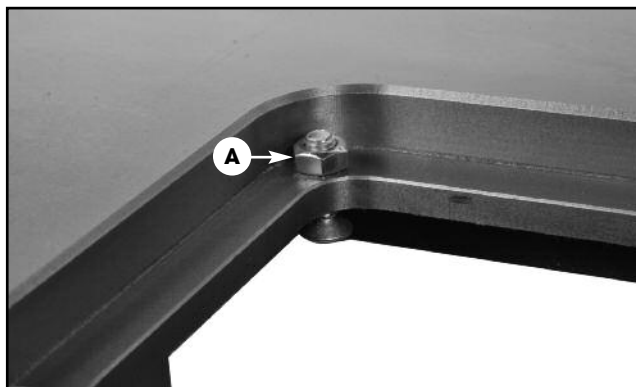
1. Place the router lift into the opening in the table.



2. Use a straightedge to test the plate for level with the table top.

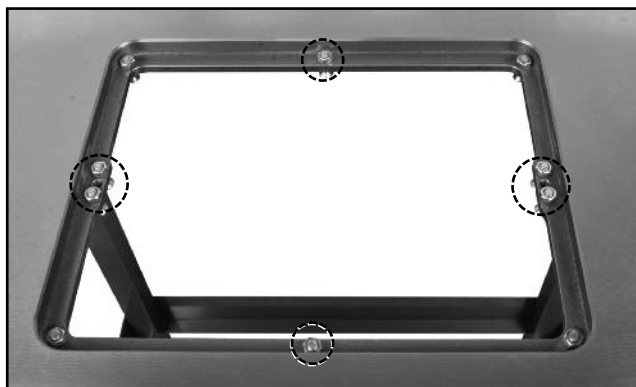


3. From the underside of the table, adjust the 4 phillips head screws in the corners **A** - up or down until the plate is flat and level with the table surface.



4. Remove the lift and lock the adjuster screw in place by turning the lock nut **A** clockwise (tighten).

**Note:** While tightening the lock nut, make sure that the adjuster screw does not turn. Confirm by re-checking the leveling of the lift and table surface.



5. After the four corners are set, proceed to set the remaining 6 leveler screws and lock them in place.



# ASSEMBLY INSTRUCTIONS - MOUNTING A ROUTER

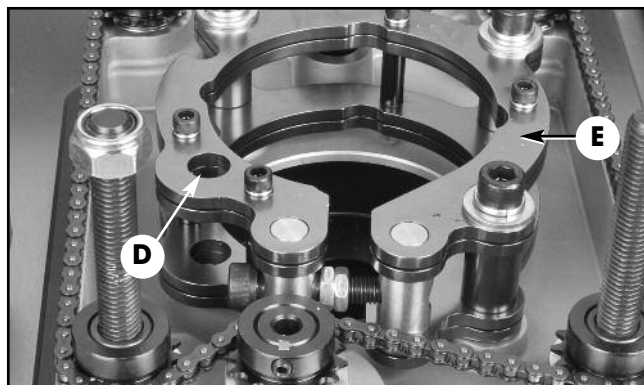
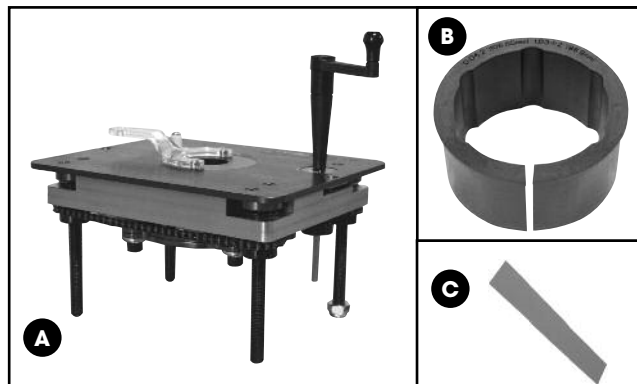


**SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.**

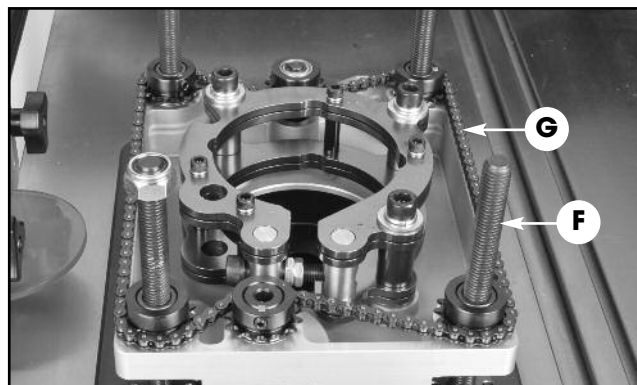
This model 40-125 "fixed base" router lift, **A** is designed to accommodate the largest diameter router motor body currently available.

**Note: Based on our research this is the Porter Cable model 7518 and 7519 router motors which measure 4.200" in diameter.**

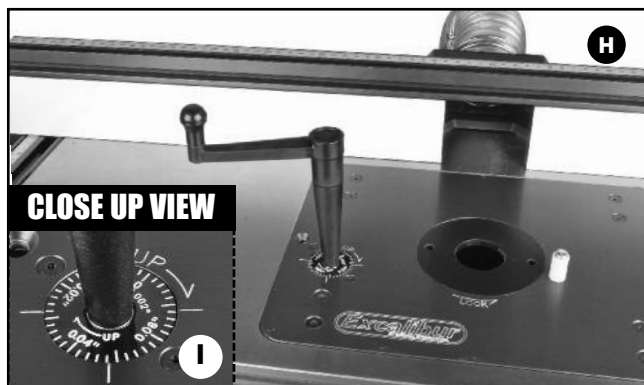
All other motors (smaller diameters) will require a shim **C** (item # 40-626, available from you local General International dealer), or a reducer collar such as our model 40-312 (for 3 1/2" motors) or 40-314 (for 3 1/4" motors), **B**, to center the router as well as prevent from overtightening the clamping system.



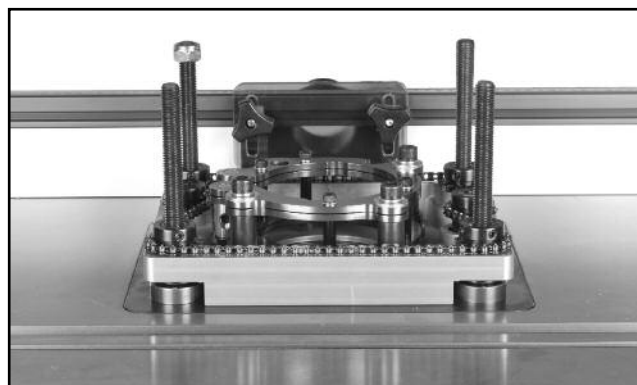
**Note: The factory installed adjusting screw on the Milwaukee motor must be lined up and inserted into the hole D located in our clamping bracket E.**



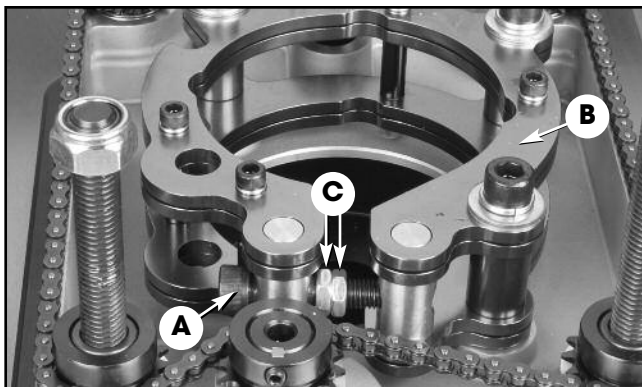
Clean packing lubricant from the lift posts/screws **F** and the chain **G**. Clean it by spraying with a solvent which will dilute the grease, and then wipe clean or use compressed air to "blow dry". After degreasing, reapply some dry lubricant.



1. Insert the crank handle in the black hole surrounded by digits as shown in **H**.
2. To raise the lifting carriage on the router lift to the highest or maximum upward position, turn the crank handle clockwise.

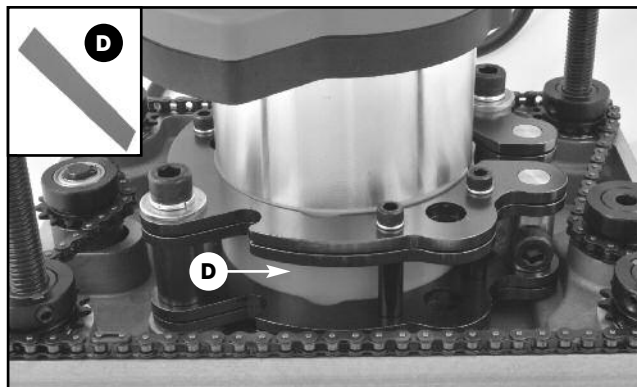


3. Remove the crank handle, and flip the lift over in the table.



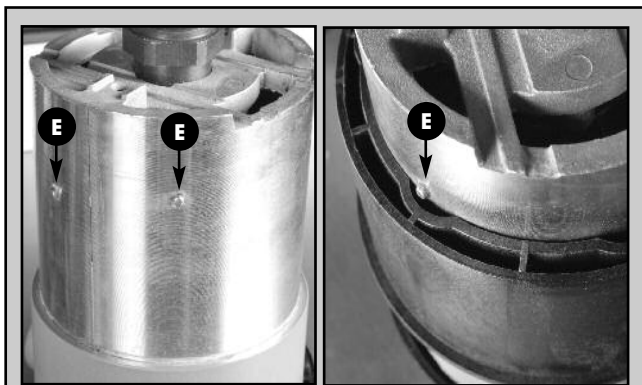
4. Turn Allen cap screw **A** counter clockwise to loosen clamp body **B**. The two threaded nuts **C** are there to help spread the clamp body.

**Note:** Spread clamping mechanism only as needed. Nuts **C** have no other purpose and you will notice that they are locked together and will sit in a neutral position when the router motor is secured into place.

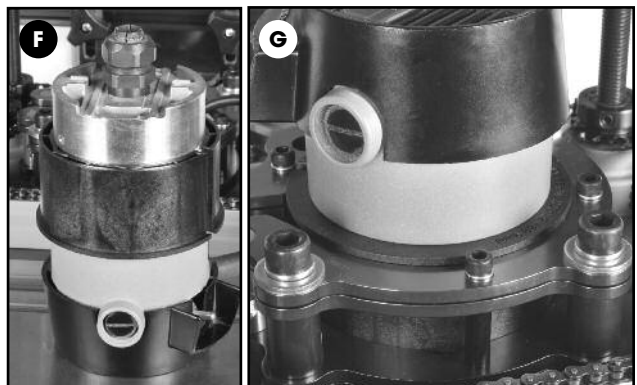


**Note:** When mounting the Milwaukee model 5625/5626 motor, please ensure that a shim **D** is between the router and the clamping surface of the lift.

5. Slide the router motor into the clamping area as shown above using shim or reducers if necessary.

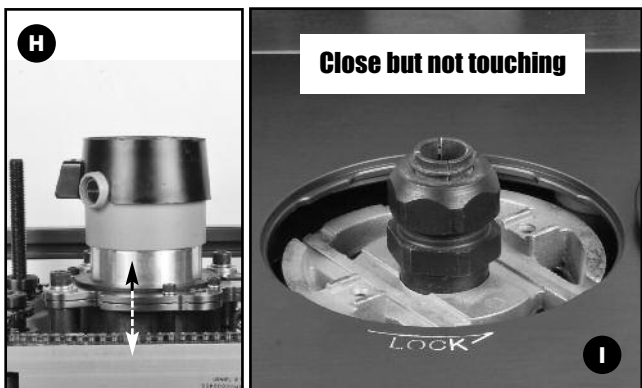


**Note:** Some motors have pins or protrusions **E** on the housing. You will need to turn/twist the motor as you slide it into the clamping area, or onto the reducer collar.

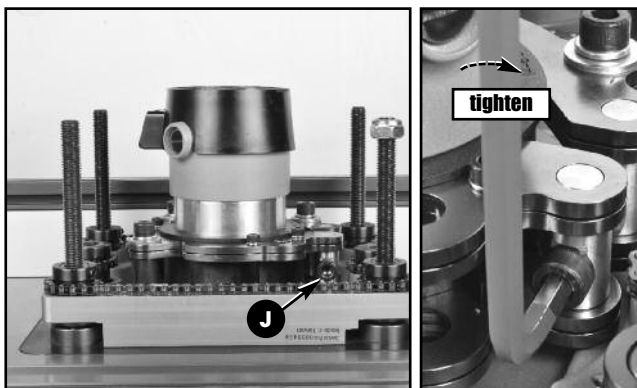


For installation with reducer collar

1. Install the collar onto the router as shown in **F**, and then fit the router with collar into the lift, **G**, making sure that the collar flange sits flush against the clamping bracket.

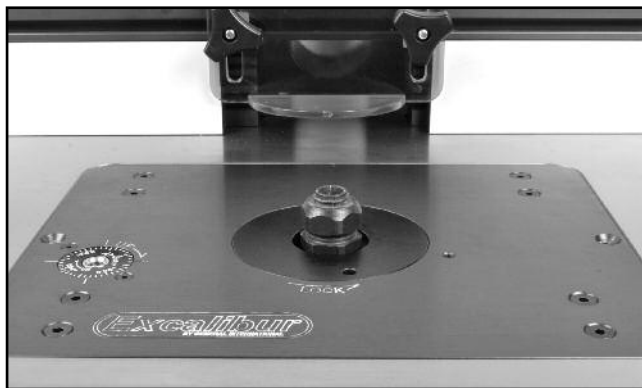


2. Adjust the height of the router in the collar **H** to ensure that the router is as close as possible to the underside of the plate without touching **I**.

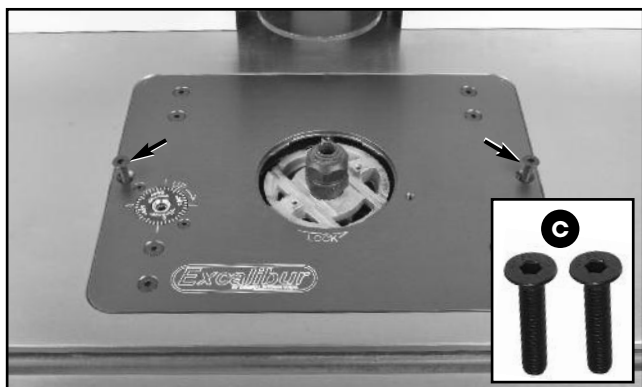


3. With the router in position, tighten clamping bolt **J** securely, using a using a 8 mm Allen key, but do not over tighten. **Important:** Test that the router is securely clamped in the reducer collar by trying to twist the router in the collar by hand.

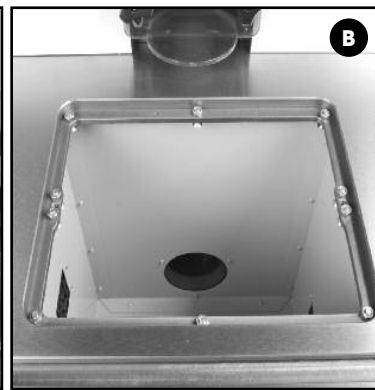




4. The router's collet should now be protruding out from the top plate. This will facilitate tool (router bit) changing from above the table eliminating the need to remove the router lift system from the table to access the collet.



## LEVELING AND LOCKING THE ROUTER PLATE



1. Using a straightedge check that the router plate is level with the main table, **A**.
2. Adjust the 10 leveling screws **B** in the table opening as needed to level the plate on all four sides. (If needed, refer back to the instructions on page 6.)

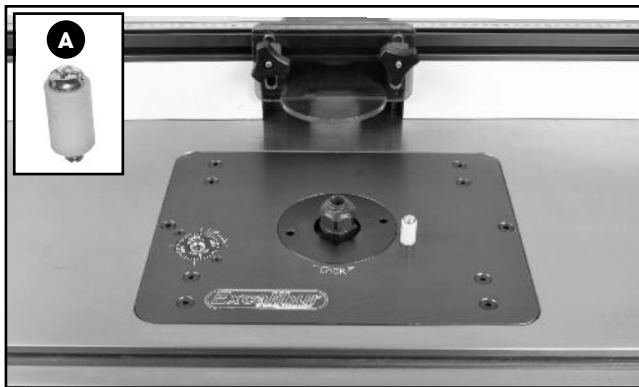
3. With the router plate leveled to the table, lock the plate in place using the two supplied hex socket head screws **C** in the threaded holes on both sides of the plate.

## INSERT RING REMOVAL



Insert the two pins of the wrench in the two holes on the insert ring then turn clockwise to unlock the ring, **A** and lift the insert ring up and out of the table insertion, **B**.

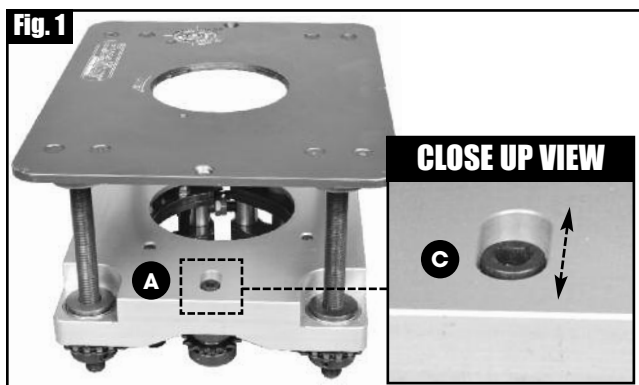
## INSTALLING THE STARTING PIN



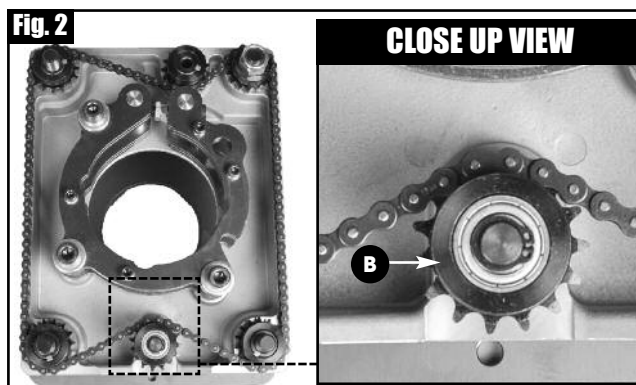
Install the starting pin **A** into the threaded hole on the router plate as shown. The starting pin can be used as needed for freehand or template routing only.

## TENSIONING THE DRIVE CHAIN

Proper tension on the drive chain helps maintain tool bit height in the lift without the need for a locking mechanism. If you experience problems with tool creep it may be a sign that tension on the chain needs to be tightened. If so proceed as follows:



1. Lower the lift to its lowest position and then remove it from the table.
2. Using a 6 mm allen key loosen the cap screw **A** (Fig.1).



3. Push the sprocket assembly **B** (Fig.2) further along its slotted opening **C** (Fig.1) by hand to add tension to the chain.
4. While holding the sprocket assembly in position, tighten the cap screw to secure it in place.

**Note:** To avoid unnecessary adjustments, make sure that the tool creep you are experiencing is not being cause by the router slipping in the reducer collar or in the clamping mechanism on the lift.

## RECOMMENDED OPTIONAL ACCESSORIES

Here are some of the optional accessories available from your local General International dealer.

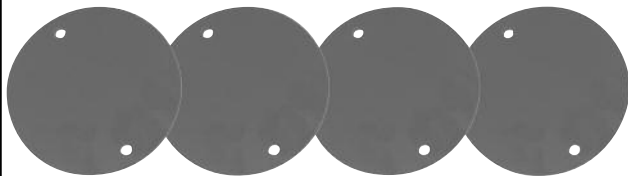
For more information about our products, please visit our website at [www.general.ca](http://www.general.ca)

### 4 PC ZERO CLEARANCE

#### INSERT RING SET

#40-074

For Excalibur 9 1/4" x 11 3/4" router plates



### 4 PC INSERT RING SET

#40-076

1/4", 1/2", 2 1/2" & 1 3/8" (30 mm for #40-099)



### REDUCER COLLAR FOR EXCALIBUR MODEL 40-125 ROUTER LIFT

#40-312

Fits 3 1/2" diameter  
routers



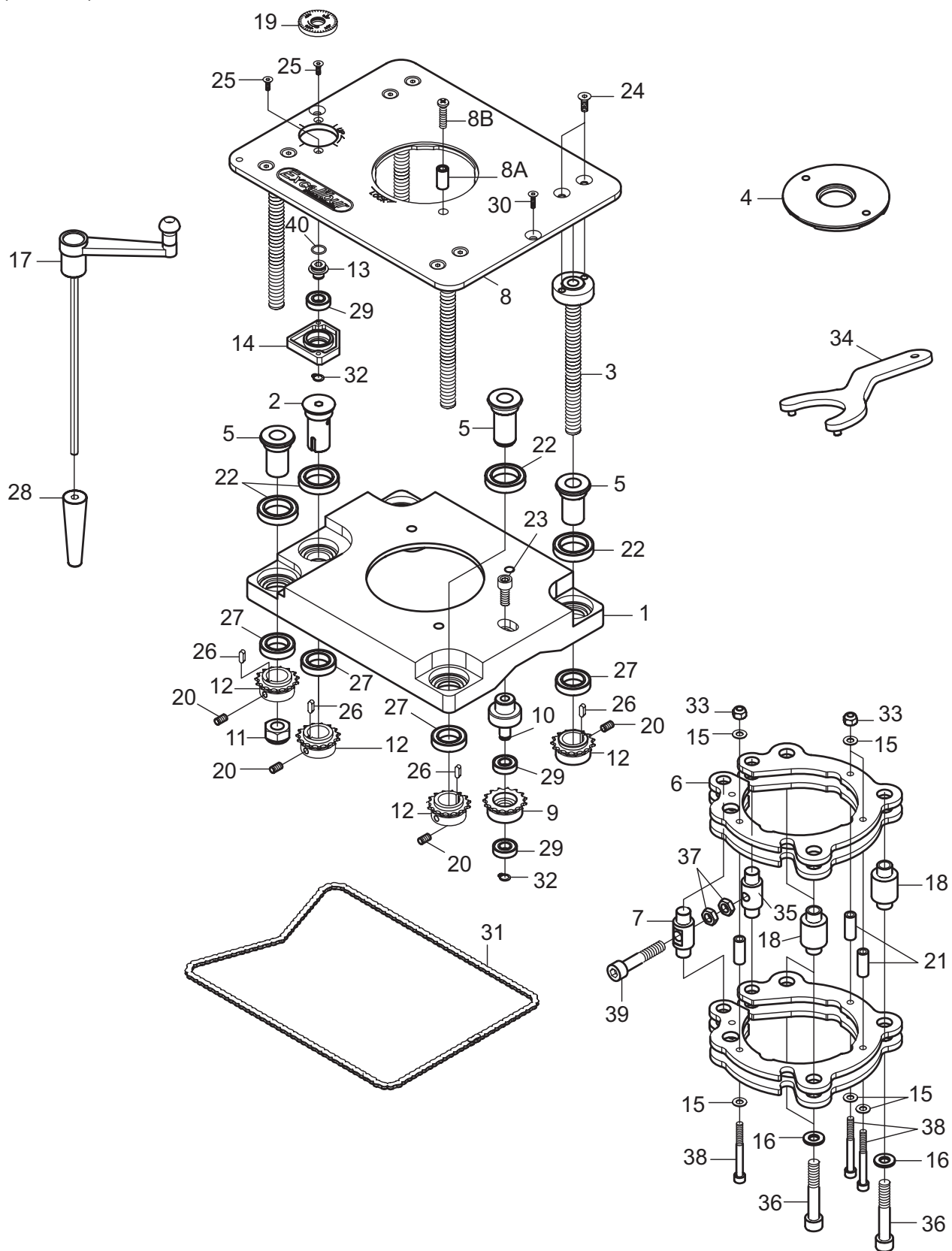
### REDUCER COLLAR FOR EXCALIBUR MODEL 40-125 ROUTER LIFT

#40-314

Fits 3 1/4" diameter  
routers



# Router lift (#40-125)



## PARTS LIST - #40-125

PART NO.	REF. NO.	DESCRIPTION	SPECIFICATIONS	QTY
40125-01	60800001A	ALUMINUM CARRIAGE BRACKET		1
40125-02	60500002	MAIN GEAR SHAFT		1
40125-03	60500003	LEAD SCREW		4
40125-04	60100017	INSERT RING	1-1/2"	1
40125-05	60500005	GEAR SHAFT		4
40125-06	60800021	CARRIAGE PLATE		4
40125-07	60800004	CLAMP POST		1
40125-08	60800007A	TOP PLATE		1
40125-08A	60700031	STARTING PIN		1
40125-08B	906M06025	PHILLIPS HEAD SCREW	M6 X 25	1
40125-09	60500009	CAM GEAR		1
40125-10	60700010	ELLIPTICAL WHEEL		1
40125-11	912M14000	NYLON NUT	M14	1
40125-12	60500012	GEAR SPROCKET		5
40125-13	60700017	LOCK GUIDE NUT		1
40125-14	60700002	UPPER GUIDE NUT BASE		1
40125-15	914M061301	FLAT WASHER	M6	8
40125-16	9140381902	FLAT WASHER	M10	3
40125-17	60700009	LIFT CRANK HANDLE		1
40125-18	60800005	SLEEVE		3
40125-19	60800018	SCALE PLATE		1
40125-20	908M06006	SET SCREW	M6 X 6	9
40125-21	60800002	BUSHING		4
40125-22	9236805Z0	BEARING	6805ZZ	5
40125-23	901M08020	CAP SCREW	M8 X 20	1
40125-24	903M06018	FLAT HEX SOCKET HEAD SCREW	M6 X 18	8
40125-25	903M04012	FLAT HEX SOCKET HEAD SCREW	M4 X 12	2
40125-26	9180404018A	KEY	M4 X 4 X 12	5
40125-27	9236804Z0	BEARING	6804ZZ	5
40125-28	60700009B	CRANK HANDLE SLEEVE		1
40125-29	9236900Z0	BEARING	6900ZZ	3
40125-30	903M06030	FLAT HEX SOCKET HEAD SCREW	M6 X 30	2
40125-31	60800020	CHAIN		1
40125-32	919S01000	C-RING	S10	2
40125-33	912M06000	NYLON NUT	M6	4
40125-34	60100018	INSERT WRENCH		1
40125-35	60800003	BACK LASH LOCK		1
40125-36	901M10070A	CAP SCREW	M10 X 70	3
40125-37	910M10005	HEX NUT	M10	2
40125-38	901M06060A	CAP SCREW	M6 X 60	4
40125-39	901M10055	CAP SCREW	M10 X 55	1
40125-40	94300002	O-RING	12.42 X 1.78	1

### NOTES:

**NOTES:**



## **MODEL 40-125**



8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3

Tel.: (514) 326-1161

Fax: (514) 326-5565 - Parts & Service / Fax: (514) 326-5555 - Order Desk

orderdesk@general.ca  
www.general.ca

### **IMPORTANT**

**When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.**